












DS

Date: Wednesday, 11/03/2009 1:00:00 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR HANDLE KIT
Job Number	: 46457		
Estimate Number	: 10292		
P.O. Number	:	Part Number	: D412698013
This Issue	: 11/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN D412-698 REVE
First Issue	: / /	Project Number	: N/A
Previous Run	: 46210	Drawing Revision	: D
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 27/03/2009
Checked & Approved By	: <u>JUD 09.03.11</u>	Qty:	4 Um: Each
Comment	: Est Rev: C Removed Manufacturing 05-11-06 JLM Est Rev: D change to rev D ECN 1104 08-01-28 DD		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-698-013CHG001 <i>S 09/04/13</i>			
2.0	46457A	HANDLE	
			
<i>S</i>	Comment: Sub-Component HANDLE 4 x D3203-1 Batch <u>B46457A x 6 B46336 x 10</u> <i>88 09/04/13</i>		
3.0	46457B	DOUBLER ASSEMBLY	
			
<i>Spe</i>	Comment: Sub-Component DOUBLER ASSEMBLY 1 x D3220-041 Batch <u>B 3556-8 B x 1 B46457 B x 3</u> <i>88 09/04/13</i>		
4.0	46457C	DOUBLER ASSEMBLY	
			
<i>S + t</i>	Comment: Sub-Component DOUBLER ASSEMBLY 1 x D3220-042 Batch <u>46457C</u> <i>88 09/04/13</i>		
5.0	46457D	DOUBLER	
			
<i>S</i>	Comment: Sub-Component DOUBLER 2 x D3220-3 Batch <u>46457</u> <i>88 09/04/13</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 1:00:00 PM
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Drawing Name: DOOR HANDLE KIT

Job Number: 46457

Part Number: D412698013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

AN960JD416L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416L Washer

M110153

8.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M109202.

9.0

MS24694S98

Screw



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 MS24694-S98

Screw

M111453 x 50
M102720 x 6 M108670 x 3
M110363 x 5 M111060 x 59

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-013

Location:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR HANDLE KIT

Job Number: 46457

Part Number: D412698013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



④

Comment: FINAL INSPECTION/W/O RELEASE

209/04/20

Job Completion



6 09/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

SHOP COPY

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ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 40487

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Revision: E

Date: 08.05.01

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 First Issue : 11 Type : MACHINED PARTS Drawing Number : IIN D412-698 REVE
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 Material :
 Due Date : 27/03/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JUD 09.03.11
 Comment : Est Rev: C Removed Manufacturing 05-11-06 JLM
 Est Rev: D change to rev D ECN 1104 08-01-28 DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-013CHG001

2.0

46457A

HANDLE



Comment: Sub-Component HANDLE

4 x D3203-1 Batch

B46457A x 6 B46336 x 10

3.0

46457B

DOUBLER ASSEMBLY



Comment: Sub-Component DOUBLER ASSEMBLY

1 x D3220-041 Batch

B 3556-8 B x 1 B46457 B x 3

4.0

46457C

DOUBLER ASSEMBLY



Comment: Sub-Component DOUBLER ASSEMBLY

1 x D3220-042 Batch

46457C

5.0

46457D

DOUBLER



Comment: Sub-Component DOUBLER

2 x D3220-3 Batch

46457D